

Work Order ID 61937

Friday, September 10, 2010 9:44:23 AM

Page 1

PRELIMINARY ISSUE

Item ID: D4172-047 Accept

Revision ID: PRELIM

Item Name: Crossbar Assembly

Start Date: 9/10/2010 Start Qty: 6.00 S

Required Date: 9/17/2010 Req'd Qty: 6.00 S

Reference:

Approvals: Process Plan: H Date: 10-9-10 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4172	PA2 <u>10-09-10</u>

100 0.00



Small Fab

Memo

0.00

Small Fab

1- Transfer drill holes, deburr and assemble as per dwg

RT 10-09-21

110

QC5- Inspect part completeness to step on W/O

0.00 inspected to PA2



QC

Memo

0.00

Quality Control

Dwg only
8/20/10

120

Identify as per dwg & Stock Location: composites 0.00



Packaging

Memo

0.00

Packaging

RT 10-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61937

Friday, September 10, 2010 9:44:23 AM



Page 2

Item ID: D4172-047

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Crossbar Assembly

Start Date: 9/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29 *[Signature]**W 10-09-23*

POSITIVE RECALL

EFFECTIVE *10-09-13*AUTH *W*RELEASED *[Signature]*DATE *10-09-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____











NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, September 10, 2010 9:44:28 AM



Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4172-7 		Manufactured	No			100	Each	0.0000	1	85			
Crossbar						B61943						10-09-21	
D4172-9 		Manufactured	No			100	Each	0.0000	1	85			
Angle						B61944						10-09-21	
D4172-10 		Manufactured	No			100	Each	0.0000	1	85			
Angle						B61945						10-09-21	
MS21075L4 OR MS21075L4N 		Purchased	No			100	Each	0.0000	6	30			
Nutplate						m115708						10-09-21	
MS20426AD3-85 		Purchased	No			100	Each	6,540.000	8	40			
RIVET						B m4179						10-09-21	

104374

110398

24

100-443887-100

11

20

m 17694

7

ST316

1466

~~105055~~

1466

~~10~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

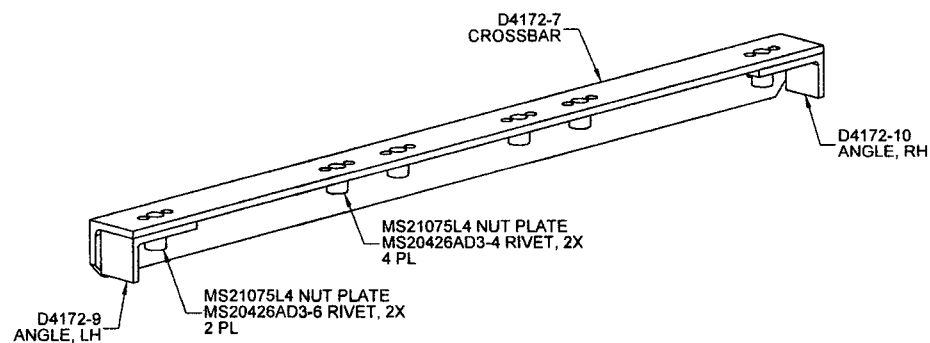
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-4	RIVET
6	4	MS20426AD3-6	RIVET



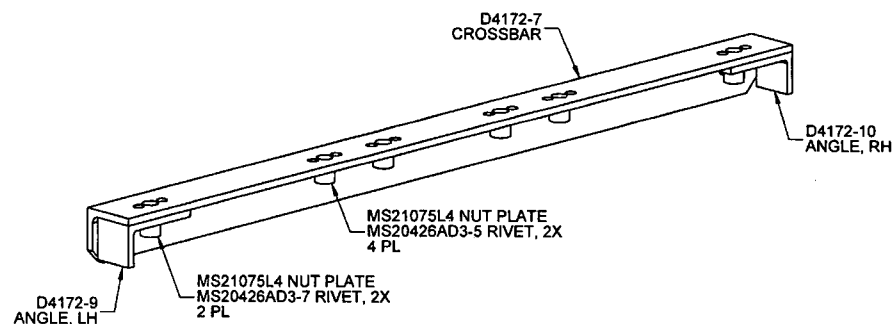
D4172-047 CROSSBAR ASSY

PRELIMINARY ISSUE
10.09.15

NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4172	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY NTS	
DATE	10.09.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY -047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET
6	4	MS20426AD3-7	RIVET



D4172-047 CROSSBAR ASSY

NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.18 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4172 SHEET 4 OF 7
APPROVED		TITLE SCALE
DE APPR.		POD MOUNTING FRAME ASSY NTS
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.